

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011550**Date Inspected:** 16-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jei/ Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

During random visual inspection of segment 11EE, this Quality Assurance inspector observed gouging on bevel face on weld designated Seg074A-010. The groove angle after fit up of SP330A and SP718A splice weld, does not comply with approved WPS-B-T-2231-B-U2-F. According to approved WPS groove angle is 60 degree (+10 degree, -0 degree), the measured groove angle is less than 60 degree. ZPMC personal performed carbon arc gouging on bevel face of SP 330A to make groove angle according to approved WPS.

For further information please see attached pictures.

**Bay#14**

Joint fit up verified by SMAW welding of weld joint Seg3003\*-005 located on Segment 12CE. Welder is identified as 049861 (1G). ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2111.

FCAW welding of weld joint CA3006-004 located on Segment 12AW. Welder is identified as 202122 (2G).

ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint CA3006C-063~068 located on Segment 12AW. Welder is identified as 201215 (3F).

ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable

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# WELDING INSPECTION REPORT

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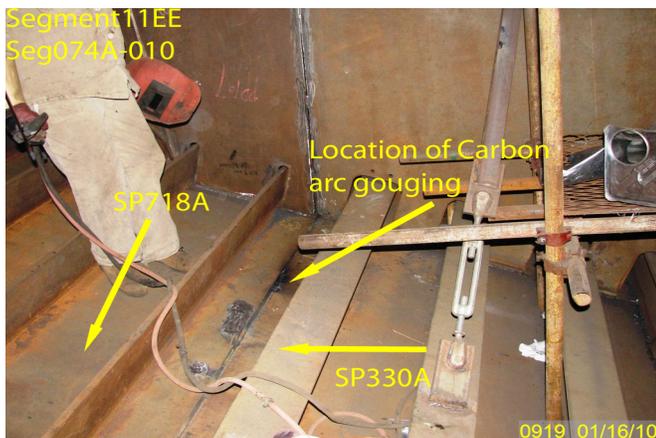
WPS-B-T-4133.

FCAW welding of weld joint CA3006C-089, 090 located on Segment 12AW. Welder is identified as 201215 (3G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint CA3006D-122, 123 located on Segment 12AW. Welder is identified as 201215 (3F). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-4133.

FCAW welding of weld joint CA3006D-132, 133 located on Segment 12AW. Welder is identified as 201215 (3G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-Tc-U4b-F.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel, Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson, Rodney	QA Reviewer

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